Work Orde													Page 1
Item ID: Revision ID:	D3911-5				Accept					Setup	Start	•	
Item Name:	Basket Stud Pl		1 6 00		8						Stop		
Start Date: Required Date: Reference:	6/4/2010 6/10/2010	Start Qty: Req'd Qty:				Cust Item I Customer:	D:						
Approvals:	Process Plan	n:		Date: <u>//-/-/-</u> /- Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									·		
D3911	C			· ·									
100 Waterjet		Men	10		0.00					10 -	6-8		
FLOW CNC Waterje	et	Prog	as per dwg Rev:	3								(1)	
		Debu	ırr as requi	red =7	Debur-	md w/c	06/08	} (16X			<u> </u>	-
110 		QC2- Inspect par		ine FAI/FAIB	0.00					10-0	· 5-8		
~~		Men	10		0.00								

Quality Control

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W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		-		· · · · · · · · · · · · · · · · · · ·						
Part No	:	PAR #:	Fault Categ	ory:	NCI	R: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	:	QA:	N/C GI	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)			·
DATE	STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
	0,1	Section A	Initial Action Description Chief Eng Chief Eng			Sign & Section (Chief Eng	QC Inspector
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					:					
				-						

Work Orde Friday, June 04,												Page 2
Item ID: Revision ID: Item Name:	D3911-5 Basket Stud P	late	A	Accept					Setup	Start Stop	· · · · · · -	##
Start Date: Required Date: Reference:	6/4/2010 6/10/2010	Start Qty: 16.00 Req'd Qty: 16.00			Cust Iten Customer						113311131	
Approvals:	Process Pla		Date:	Tooling:		Date:			Run	Start Stop		
Sequence ID/ Work Center II 120 QC Quality Control)	Operation Description QC8- Inspect parts - second	l check	Set Up/ Run Hours 0.00 0.00 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
130 Packaging Packaging		Identify as per dwg & Stock Memo	c Location:	0.00			*	(16)	1	B	10/0	06/09
140		OC21- Final Inspection - W	ork Order Release	0.00								

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

QC

Quality Control

MF 10-6-10

Dart A	Aeros	pace	Ltd
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W/O:			WC	RK ORDER CHANGI	ES				•
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	Re	esolution:	Disposition	1:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
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		•						_	

Picklist Print

Friday, June 04, 2010 9:23:52 AM

Work Order ID: 59427

Parent Item:

D3911-5

Parent Item Name:

Basket Stud Plate

Comments:

IPP RevA: new issue DD 09.11.17 verified by:EC

AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV:B

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name

M304S11GA

Replacement Mfg/ Item ID

Purch Purchased Bin Primary Item Location No

Last Location

114488

114799

Route Seq ID 100

Unit of Qty on Measure Hand sf 151.7669

Qty per Kit 0.0299

Otv Issued 0.503579

Qty

Total

Date Issued

1810-6-8

Status

Page 1

304/316 0.125 Sheet

Location

MAT

Loc Qty 151.7669

23.7669 128 Loc Code

114488



Dart Aero	ospace	Ltd
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W/O:			WC	RK ORDER CHANC	GES					
DATE	STEP	PR	OCEDURE CHAI	IGE	ı	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cateç	gory:	_ NCR:	Yes N	lo DQ	A:	Date:	
		solution:								
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCR)		-		
DATE	STEP	Description of NC		tion B		Verific	cation	Approval	Approval	
	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C			Chief Eng	QC Inspector
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	<u> </u>									

DART AEROSPACE LTD	Work Order:	39427
Description: Basket Stud Plate	Part Number:	D3911-5
Inspection Dwg: D3911 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	,130	¥			
Ø0.257	+0.006/-0.001	259	10			
0.375	+/-0.010	377	b			
0.065	+/-0.010	, ७५७	7			
0.375	+/-0.010	:373	X.	,		
1.62	+/-0.030	1.60	yb-			
0.50	+/-0.030	-501	*			
1.000	+/-0.010	,વુવવ	*			
0.500 Pitch	+/-0.010	.500	*			
2.15	+/-0.030	2,15	*			
1.000	+/-0.010	,૧વ૬	*			
0.50	+/-0.030	.498	Y			
2.00	+/-0.030	0,610	×			
0.125	+/-0.010	1193	*			
				- "		

Measured by:	围	Audited by:	Preliminary Approval:	4	1
Date:	10-6-8	Date: 10/66/08	Date:		4

Rev	Date	Change	Revised by	Approved
Α	10.04.20	New Issue	KJ 🛠	All

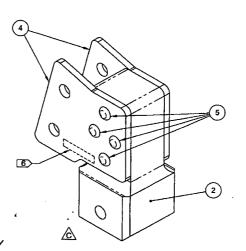
Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PR	PROCEDURE CHANGE By						Approval QC Inspector	
		· ·								
Part No		PAR #:								
	R					Closed: Date:				
NCR:		•	WORK ORD	ER NON-CONFORMA	NCE (NCF	R)				
DATE	STEP	Description of NC		on B	Verific	cation Approval		Approval		
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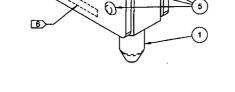
QTY -041 QTY -043 ITEM P/N DESCRIPTION х D3911-041 BASKET INSTL STUD ASSY (LOWER) Х D3911-043 AFT EYEBOLT RECEIVER ASSY D3911-1 BASKET INSTL STUD (LOWER) 2 D3911-3 AFT EYEBOLT RECEIVER 3 2 D3911-5 BASKET STUD PLATE D3911-7 BASKET PLATE-EYEBOLT RECEIVER 5 MS20615-4M20 RIVET

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 59427 B\$10-6-04







D3911-041 BASKET INSTL STUD ASSY (LOWER)

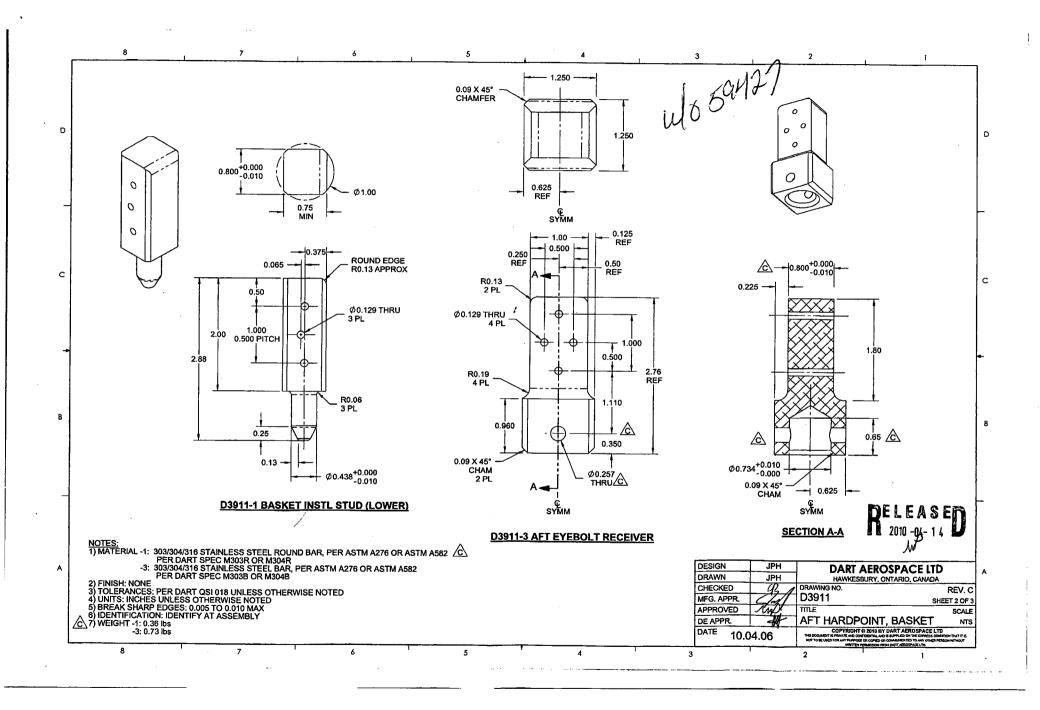
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING
FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs

С	D3911-0	SY. WEIGHT UI 143 & D3911-3 D	8 MS21209-C610 REMOVED FROM PDATED. 03911-3 REDESIGNED. DETAIL UPDATED. MTL SPEC T 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06		
В	DIAMET	ER (B3-2) AND	DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16		
_ A_	NEW IS	SUE		JPH	10.03.04		
REV.	<u> </u>		DESCRIPTION	DATE			
DESIGN JPH			DART AEROSPACE LTD				
DRAWN		JPH	HAWKESBURY, ONTAR				
CHECK	ED	100	DRAWING NO.		REV. C		
MFG. APPR.		Chill	D3911		SHEET 1 OF 3		
APPROVED		MD.	TITLE		SCALE		
DE APPR.		-141	AFT HARDPOINT, BA	SKET	NTS		
DATE	10.0	4.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DOCUMENT IS MOVED AND OF SHEPLED ON THE SPIRES CONDITION THAT IT IS				

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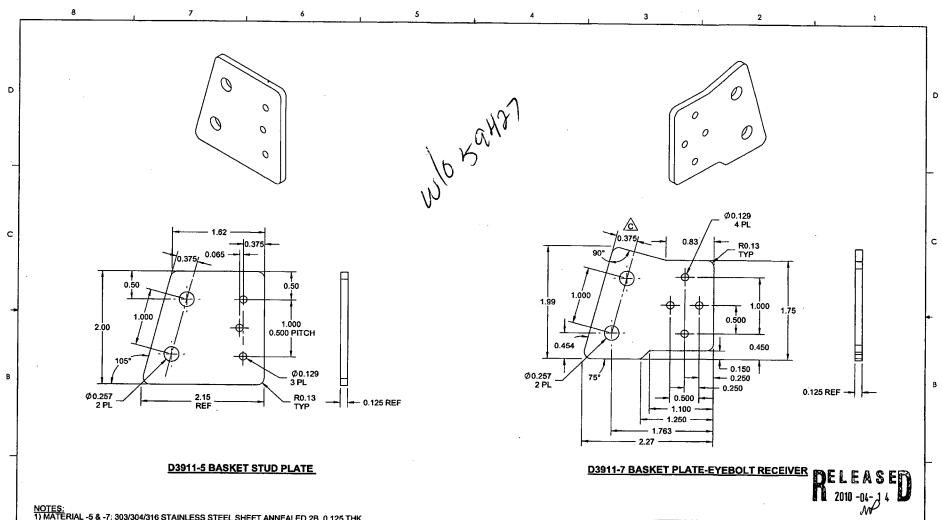
Dart A	erospace	Ltd
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W/O:			W	ORK ORDER CHANG	SES								
DATE STEP		PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Cate	gory:	_ NCF	: Yes	No DQ	A:	Date:				
Resolution:			Dispositio	n:	QA: N/C Closed: Date:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng	Section B tion Sign & Date		Verific Secti		Approval Chief Eng	Approval QC Inspector			
			Office Ling	Ciliei Eng		Date			***************************************				



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W/O:			W	ORK ORDER CHAN	NGES			 ,		
DATE	STEP	PR	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	Corrective Action Section			Ciam 9	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Section	on C	Chief Eng	QC Inspector



NOTES: 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 PER DART SPEC M304S11GA OR M303S11GA

7

Α

- PER DART SPEC M304S11GA OR M303S11GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 7) WEIGHT -5: 0.13 lbs
 -7: 0.13 lbs

8

DESIGN JPH DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. C D3911 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE SCALE AFT HARDPOINT, BASKET

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W/O:			WC	RK ORDER CHAN	IGES					·····	
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	nes	solution:							Date:		
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DATE	STEP Description of NC		Corrective Action Section B			Verifica			Approval	Approval	
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